

ASAP

Date: Wednesday, 16/04/2008 3:53:41 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JOGGLE BRACKET		
Job Number	: 38648					
Estimate Number	: 12912					
P.O. Number	:		Part Number	:	D35801	
This Issue	: 16/04/2008	S.O. No.	: :	Drawing Number	: D3580 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: B	
Previous Run	: 35983			Material	:	
Written By	:			Due Date	: 21/04/2008	Qty: 30 Um: Each
Checked & Approved By	<u>JLD 08-4-16</u>					
Comment	: Est Rev:A New Issue 07.06.25 EC Est Rev:B Removed Powder Coat 07-07-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S18GA	304/316 .050 Sheet	
		.5	
		Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.3150 sf(s) 304/316 SS sheet 0.050" thick	
		Batch: <u>100997</u> HB 8-4-17	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3580	
		Dwg Rev: <u>B</u> HB 8-4-17	(32)
		Prog Rev: <u>B</u>	
		2-Deburr if necessary	SB 08/04/22 (32)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-4-17	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	C 08/04/22 (X32) coverts
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: Bend as per dwg D3580 using 1/8" offset die	SB 08/04/23 (32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/04/2008 3:53:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: JOGGLE BRACKET
Job Number: 38648		Part Number: D35801
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 S 08/04/03 K32
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 110		 AS 08/04/03 K32
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 08/04/24 K32
Job Completion		 MF 08-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38648
Description: Joggle Bracket	Part Number:	D3580-1
Inspection Dwg: D3580 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JB
Date:	8-4-17

Audited by:	
Date:	18/04/22

Prototype Approval:	N/A
Date:	N/A

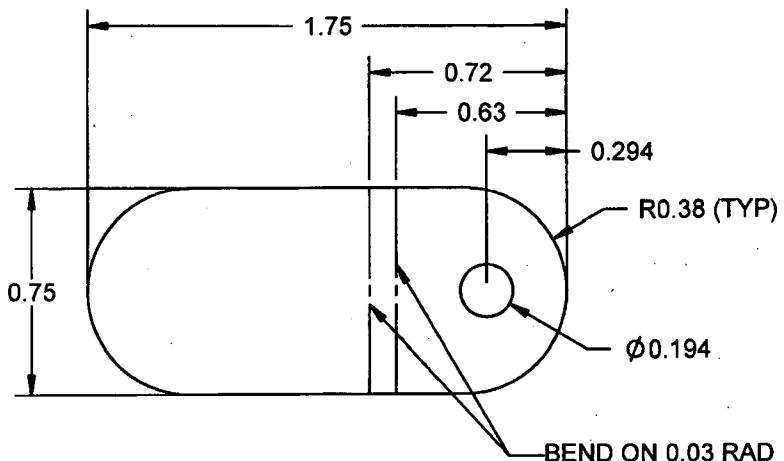
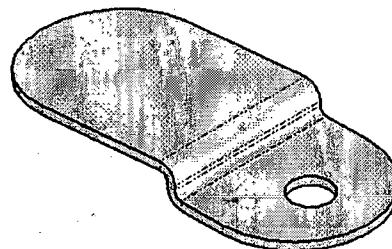
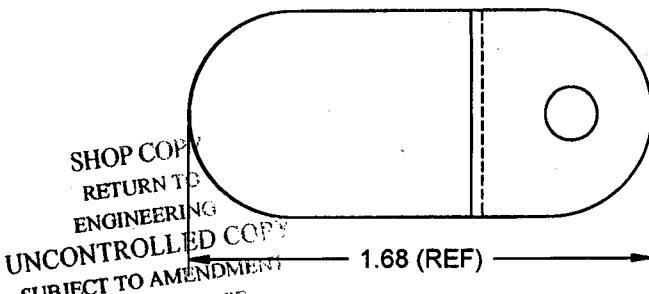
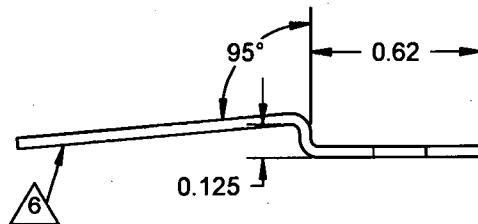
Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D3580
DATE 07.07.09		REV. B SHEET 1 OF 1 TITLE JOGGLE BRACKET SCALE 3:2

RELEASED07.07.09 *CH*

REV	DATE	DESCRIPTION
A	07.05.15	NEW ISSUE
B	07.07.09	REMOVE POWDER COAT

**D3580-1F FLAT PATTERN****D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED